

Date: Friday, 17/10/2008 12:43:48 PM
 User: Julie Dawson

Process Sheet

| | | | |
|------------------------------------|--|---------------------------|------------------------|
| Customer : | CU-DAR001 Dart Helicopters Services | Drawing Name : | 350/212/130 BASKET LID |
| Job Number : | 42721B | | |
| Estimate Number : | 10193 | | |
| P.O. Number : | | Part Number : | D2512 |
| This Issue : | 17/10/2008 | S.O. No. : | |
| Prsht Rev. : | NC | Drawing Number : | D2512 REVE |
| First Issue : | // | Project Number : | N/A |
| Previous Run : | 41624A | Drawing Revision : | E |
| | Type : | Material : | |
| | LARGE FAB ASSY | Due Date : | 05/11/2008 |
| Written By : | | Qty: | 1 Um: Each |
| Checked & Approved By : | <u>JLD 08.10.17</u> | | |
| Comment : | Rev Est:M 03.01.31 Added D2012-117 for D130-701-041 KJ/ RF Est Rev:N 06.04.05 Added level21 EC Est Rev:O 08-08-29 revE as per dwg DD verified by:EC Est Rev:P 08-09-24 plug holes prior to powder coating DD verified by:EC | | |

Additional Product

Job Number:



| | | |
|----------------|------------------------------|----------------------|
| Seq. #: | Machine Or Operation: | Description : |
|----------------|------------------------------|----------------------|

| | | |
|-----|----------------|---------------------------|
| 1.0 | M304TS0750W065 | 304 SQ Tube .75x.75x.065W |
|-----|----------------|---------------------------|



✓
Comment: Qty.: 45.7594 f(s)/Unit Total: 45.7594 f(s)

Pick:

3/4"x3/4" 304/316 SS tube .065" wall

Batch: M110011

SAD 08-12-18

| | | |
|-----|--------|-------------|
| 2.0 | D31663 | Basket Hoop |
|-----|--------|-------------|



✓
Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3166-3

Basket Hoop

B42717

SAD 08-12-18

| | | |
|-----|-------|-------------|
| 3.0 | D2506 | Label Plate |
|-----|-------|-------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2506

Label Plate

339457

Cpl 08-12-18

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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| | | | | | | | | |

NOTE: Date & initial all entries

Date: Friday, 17/10/2008 12:43:48 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/212/130 BASKET LID

Job Number: 42721B

Part Number: D2512

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|-----|--------|----------------|
| 4.0 | D23271 | Spacer Bushing |
|-----|--------|----------------|



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

| Qty | Part Number | Description |
|-----|-------------|-------------|
| 2 | D2327-1 | Bushing |

Batch

B40390

Pl 08-12-29

| | | |
|-----|--------|--------------|
| 5.0 | D22321 | Basket Hinge |
|-----|--------|--------------|



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

| Qty | Part Number | Description |
|-----|-------------|-------------|
| 2 | D2232-1 | Hinge plate |

Batch

B39454

Sl 08/12/30

| | | |
|-----|-------|------------------|
| 6.0 | D2581 | Mounting Bracket |
|-----|-------|------------------|



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

| Qty | Part Number | Description |
|-----|-------------|------------------|
| 2 | D2581 | Mounting Bracket |

Batch

B 40895

Sl 08/12/30

| | | |
|-----|--------------|------------------------|
| 7.0 | M304EX07516F | Expanded Metal Flat SS |
|-----|--------------|------------------------|



Comment: Qty.: 18.0000 sf(s)/Unit Total : 18.0000 sf(s)

Pick:

| Qty | Part Number | Description |
|-------|----------------|----------------|
| 18 sf | M304EX0.75-16F | Expanded Metal |

Batch

M109 383 (2)

M107 510 (16) *SAD 08-12-30*

(2)

| | | |
|-----|-------------|------------------------------|
| 8.0 | LARGE FAB 1 | LARGE FABRICATION RESOURCE 1 |
|-----|-------------|------------------------------|



Comment: LARGE FABRICATION RESOURCE 1

1-Cut 3/4" x 3/4" square tubing as per Dwg D2512

2-Cut (4) D2236 From D3166-3

3-Drill holes in D2512-1 as per Dwg D2512 using Drill Jig DT8305

5-Weld as per Dwg D2512 using Welding Table and corner Jig Deburr as required

Sl 08/12/30

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/212/130 BASKET LID

Job Number: 42721B

Part Number: D2512

Job Number:



Seq. #: Machine Or Operation: Description :

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

11/09/07

10.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

S 07/01/07

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

m 109996

1- Plug holes in D2581 and in D2327-1 bushing prior to powder coating

2- Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

1ST COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1:05
400°
1:35

2ND COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

FL 09/01/07

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk and Spray Paint black as per Dwg D2512 and QSI 005 4.4

Batch:

FL 09/01/07

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

S 07/01/07

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

DPP 42721

9/1/08

(K)

SL

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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Drawing Name: 350/212/130 BASKET LID

Job Number: 42721B

Part Number: D2512

Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

QC21

FINAL INSPECTION/W/O RELEASE



09/01/12 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-01-09

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

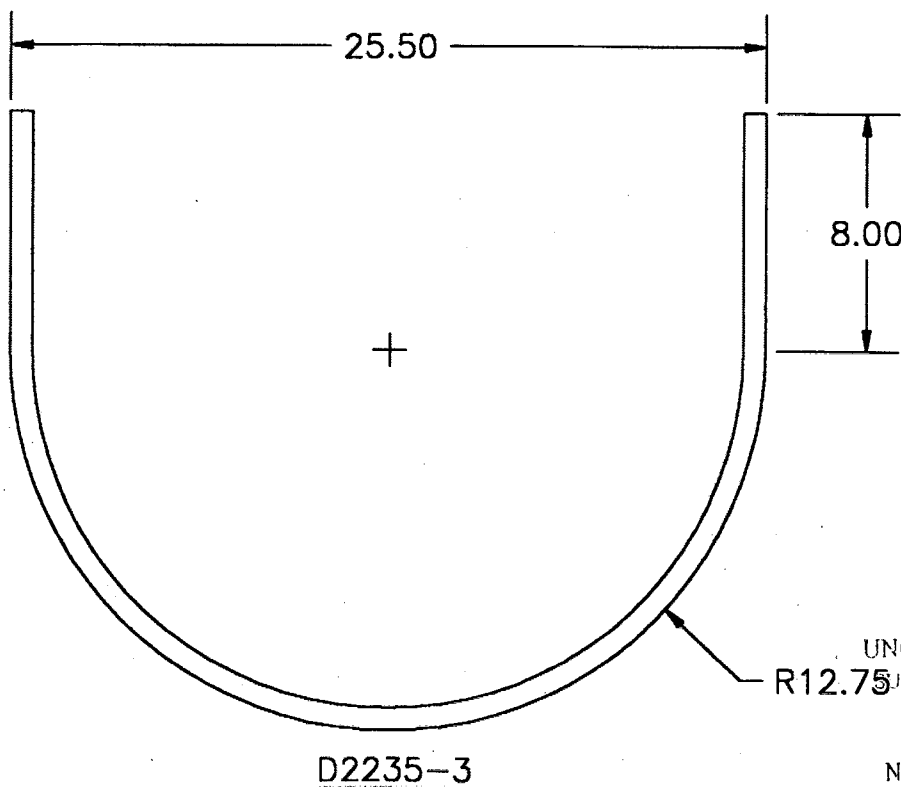
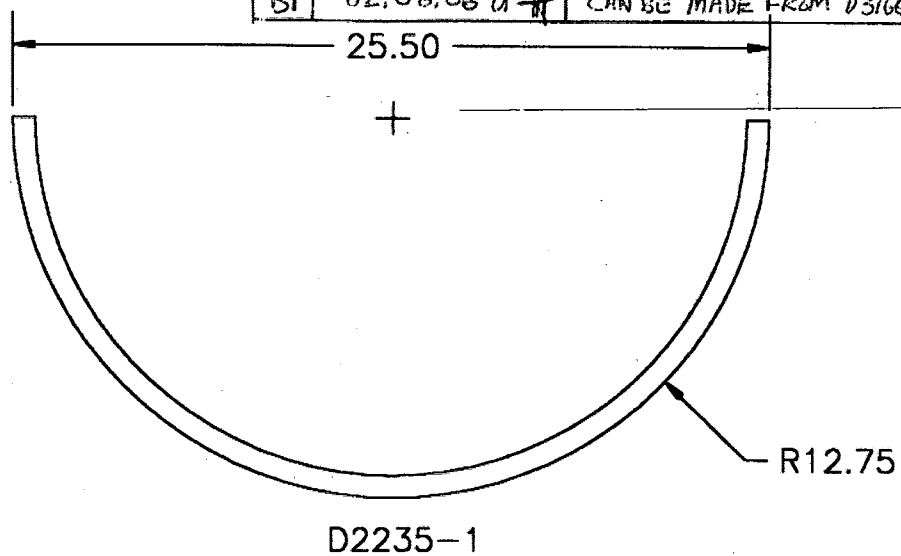
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries



| | | | |
|-------------------------------|--------------------------------|--|------------------------|
| DESIGN B WILLIAMS | DRAWN BY B WILLIAMS | DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D2235 | REV. B SHEET 1 OF 1 |
| DATE 94:12:16 | | TITLE BASKET RIBS | |
| BI 02.08.06 <i>[initials]</i> | | CAN BE MADE FROM D3166-1 | |

RELEASED
R 960507

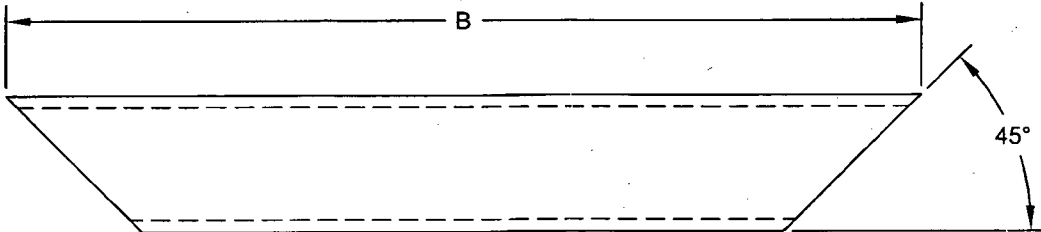
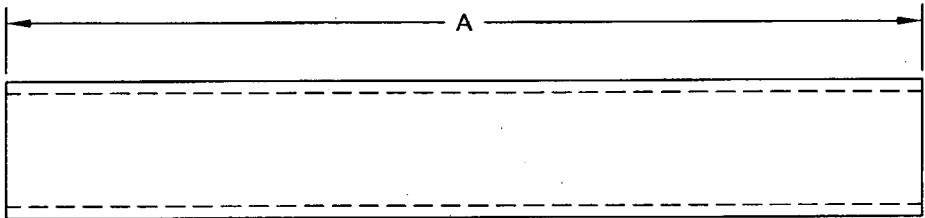
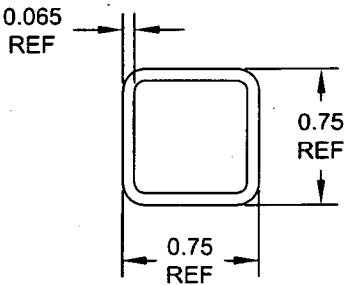
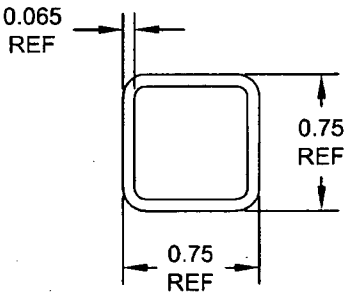


CAN BE MADE FROM D3166-1 *[BI]*
MATERIAL: 304/316 SS, 3/4 X 3/4 X 0.063 WALL SQR.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *427213*

PARTS LIST FOR D2512 BASKET LID ASSEMBLY

| PART NO | QUANTITY | LENGTH A | LENGTH B | DESCRIPTION |
|---------|----------|-------------|-------------|------------------|
| D2512-1 | 2 | | 25.50 | RIB |
| D2512-3 | 2 | | 95.30 | RIB |
| D2512-5 | 6 | 30.84 | | RIB |
| D2512-7 | 3 | 30.63 | | RIB |
| D2232-1 | 2 | N/A | N/A | HINGE PLATE |
| D2236 | 4 | N/A | N/A | RIB |
| D2327-1 | 2 | N/A | N/A | BUSHING |
| D2506 | 1 | N/A | N/A | LABEL PLATE |
| D2581 | 2 | N/A | N/A | MOUNTING BRACKET |



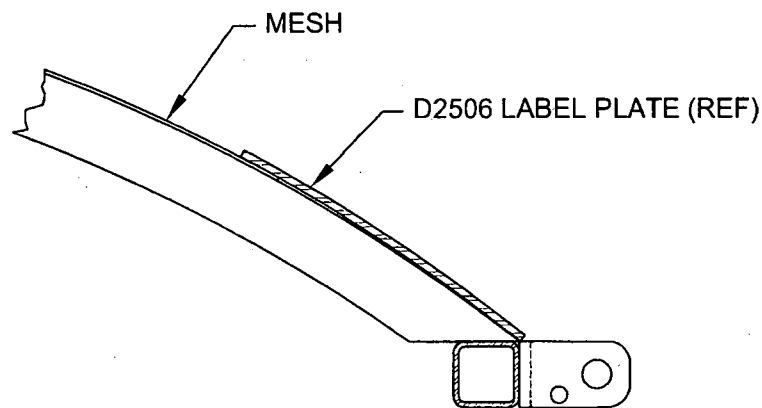
- D2512-1/-3/-5/-7 NOTES:**
- 1) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: N/A
 - 8) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST

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WORK ORDER
NO. 40721B

RELEASED
08-08-21/11

| | | | |
|------------|--|--|--------------|
| E | INCORPORATED D1 & D2. MATERIAL FOR -1, -3, -5, & -7 WAS 0.060 WALL. SHT 3 ZN C4 TOLERANCE REMOVED FROM 95.30 DIM. DRAWING TRANSFERRED TO "B" FORMAT AND UPADTED TO CURRENT STANDARDS. SHT 3 VIEWS INVERTED FOR CLARITY. SHT 2 MESH MATERIAL CALLOUT UPDATED. | AJS | 08.06.17 |
| D | CHANGE HINGE | CP | 01.04.19 |
| C | REMOVE DOUBLE SKIN SECTION, ADDED MEMBERS, INCORP DEO 9074 | DS | 99.07.06 |
| B | ADDED LATCH CHANNEL & LABEL PLATE | BW | 96.05.24 |
| A | NEW ISSUE | BW | 95.11.21 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | BW | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | AJS | | |
| CHECKED | | DRAWING NO. | REV. E |
| MFG. APPR. | | D2512 | SHEET 1 OF 4 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | BASKET LID ASSEMBLY (350/212) | NTS |
| DATE | 08.06.17 | COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | |

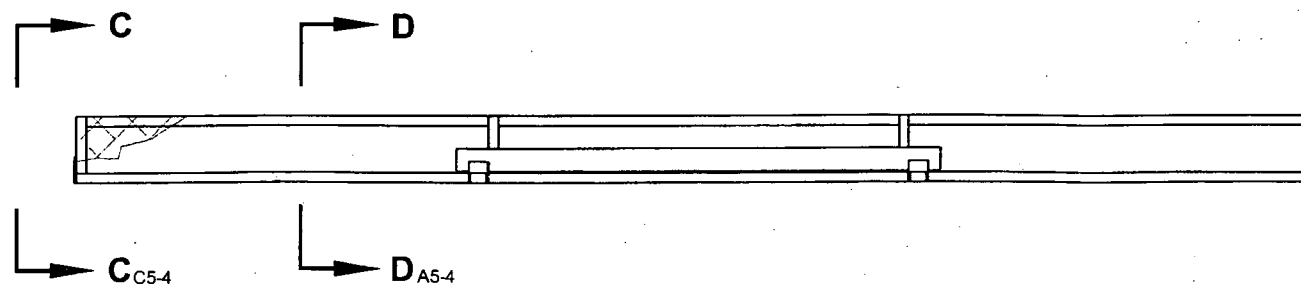
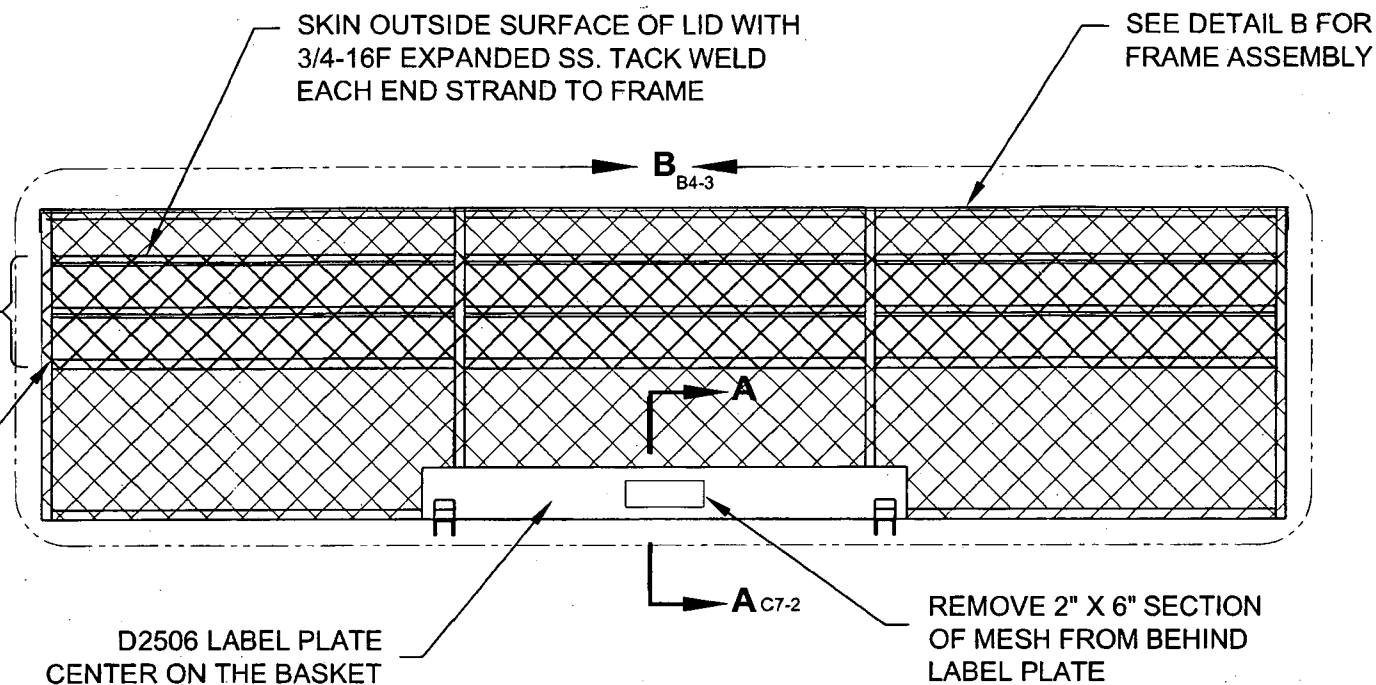
8 7 6 5 4 3 2 1



SECTION A-A_{B3-2}
(ROTATED 90° CCW)

FINISH THIS SECTION ALONG
ENTIRE LENGTH PER NOTE 3
AFTER POWDER COAT.

TACK WELD MESH TO FRAME
AT EVERY AVAILABLE LOCATION
IN AREA TO BE ANTI-SKIDDED



D2512 BASKET LID ASSEMBLY NOTES:

- 1) MESH MATERIAL: 3/4-16F EXPANDED SS
REF DART SPEC M304EX0.75-16F
- 2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) SPRAY PAINT BLACK INSIDE SURFACE
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE PER DART QSI 005 4.4
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: N/A
- 9) WELD PER DART QSI 004

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NO. 412218

RELEASED
08.06.17

| | | | |
|------------|----------|--|--------------|
| DESIGN | BW | DART AEROSPACE LTD | |
| DRAWN | AJS | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. E |
| MFG. APPR. | | D2512 | SHEET 2 OF 4 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | BASKET LID ASSEMBLY (350/212) | NTS |
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8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1

D

D

C

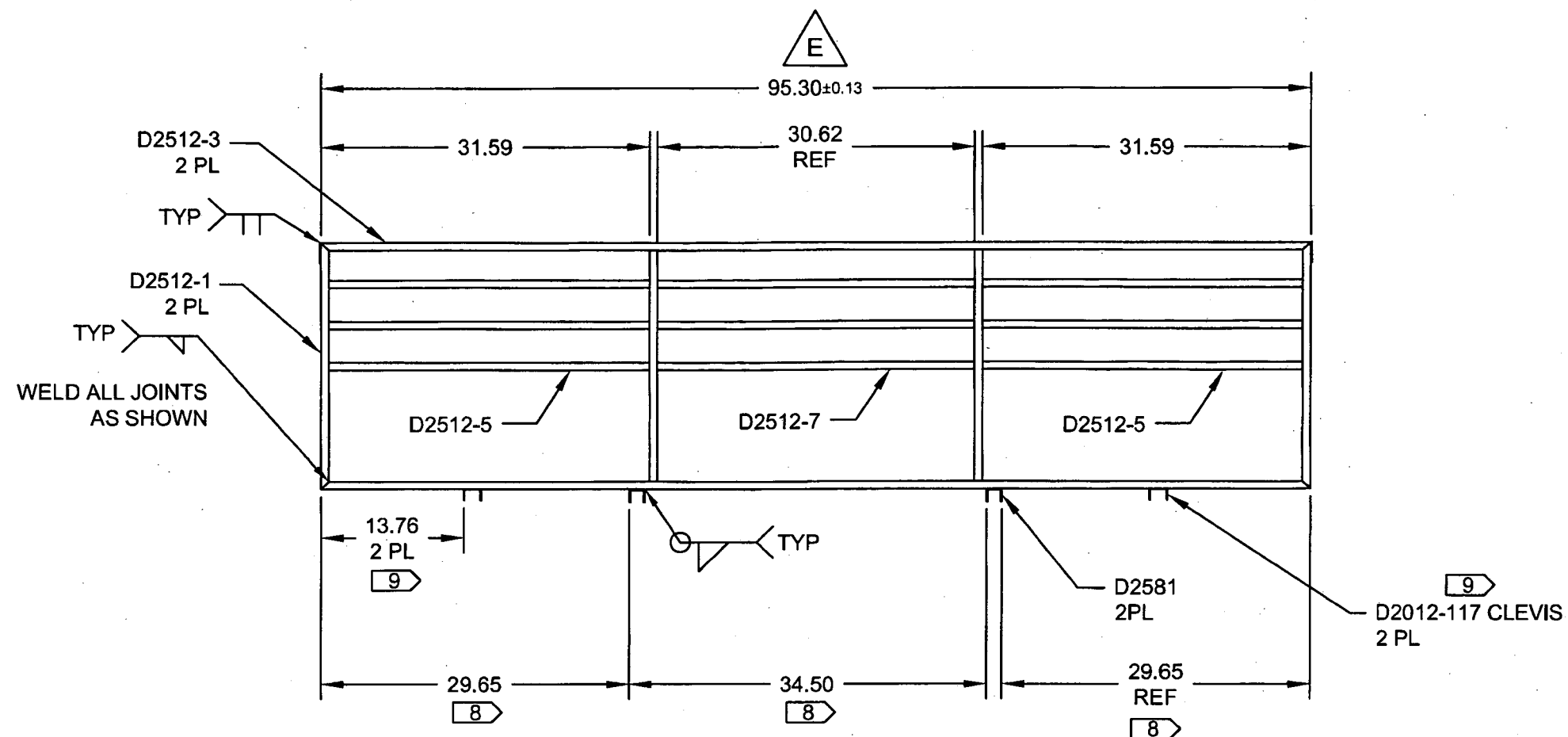
C

B

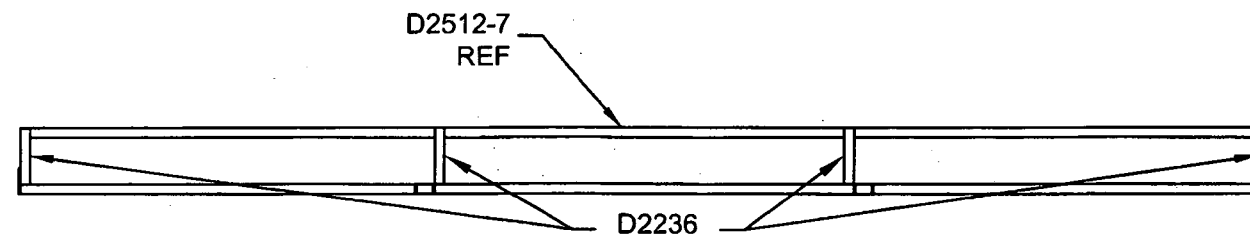
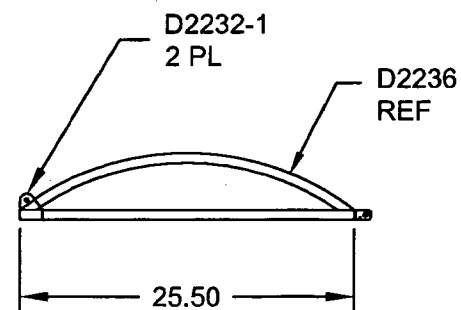
B

A

A



DETAIL B C3-2
FRAMEWORK ONLY SHOWN FOR CLARITY



- NOTES:**
- 1) MATERIAL: NONE
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: N/A
 - 8) LOCATE IN CONJUNCTION WITH ADJACENT D2581 ON BASKET BASE ASSEMBLY
 - 9) FOR D130-701-041 ONLY

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RELEASED
08-06-17 11:15 421213

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|------------|----------|--|--------------|
| DESIGN | BW | DART AEROSPACE LTD | |
| DRAWN | AJS | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. E |
| MFG. APPR. | | D2512 | SHEET 3 OF 4 |
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8 7 6 5 4 3 2 1

8

7

6

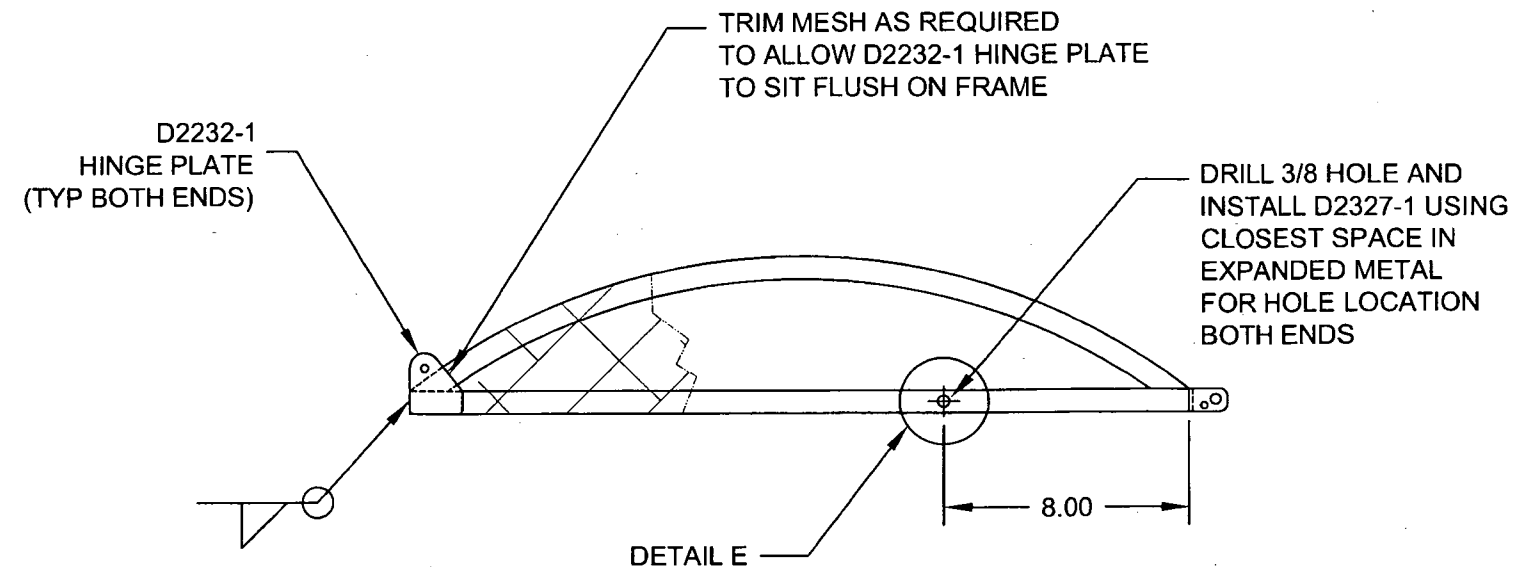
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4

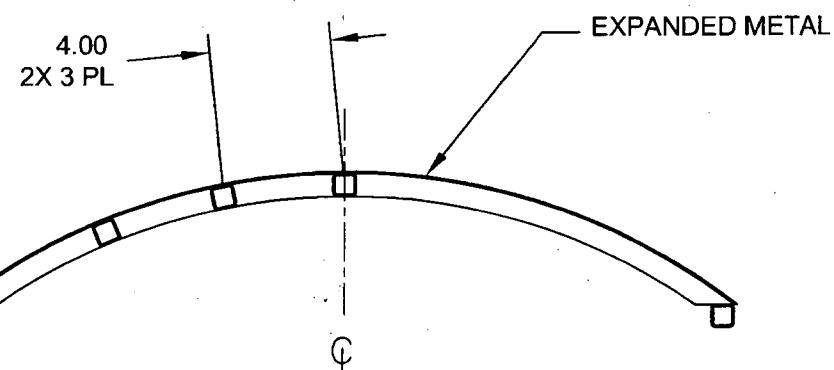
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2

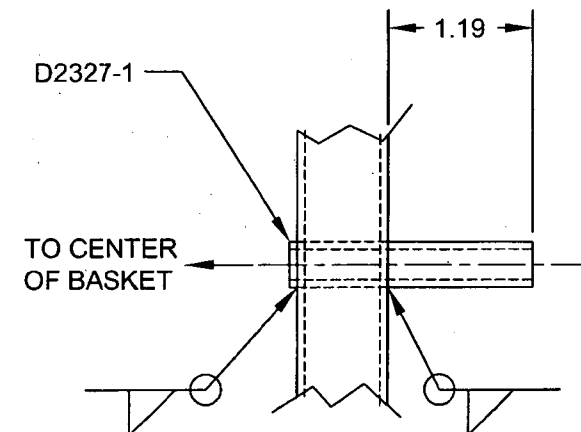
1



VIEW C-C SIMILAR BOTH END RIBS A5-2



SECTION D-D SAME BOTH CENTER RIBS A4-2



DETAIL E C6-4

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|------------|----------|--|--------------|
| DESIGN | BW | DART AEROSPACE LTD | |
| DRAWN | AJS | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. E |
| MFG. APPR. | | D2512 | SHEET 4 OF 4 |
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